

Date: Thursday, 6/21/2007 2:30:02 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 33076		
Estimate Number	: 12337		
P.O. Number	: N/A	Part Number	: D3492043
This Issue	: 6/21/2007 S.O. No. : N/A	Drawing Number	: D3492 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 32997	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 7/3/2007
Checked & Approved By	: <u>[Signature] 07.06.22</u>	Qty:	80 Um: Each
Comment	: Est Rev: A 06.03.21 New Issue JLM Est Rev: B 06-08-28 As per Rev B JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6R0750	6061-T6 Round Bar .750"
-----	--------------	-------------------------



Comment: Qty.: 0.0656 f(s)/Unit Total : 5.2500 f(s)  
 6061-T6 Round Bar .750"  
 (M6061T6R750)  
 Batch: 11102 857

20 07/28/11 + 12

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA632 & Dwg D3492  
 Dwg Rev: B  
 Folio Rev: B

20 07/28/11 + 12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 07/28/11 + 12

(92)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 07.08.13

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr

[Signature] 07.08.13 (92)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/09/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:30:02 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 33076

Part Number: D3492043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(92x)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

07/08/15

7.0

POWDER COATING

POWDER COATING



(92)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

BL/FZ

07-08-21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(92x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

07/08/21

9.0

NAS1611013

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-013 O-RING

M/03500

FZ

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch: M/01223

FZ 07/08/27

(92)

11.0

QC5

INSPECT WORK TO CURRENT STEP



M 07 09 06

Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



(92x)

Comment: PACKAGING RESOURCE #1

F-P16

M-L

07/09/06

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(92)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/09/06

Job Completion



U 07/09/06

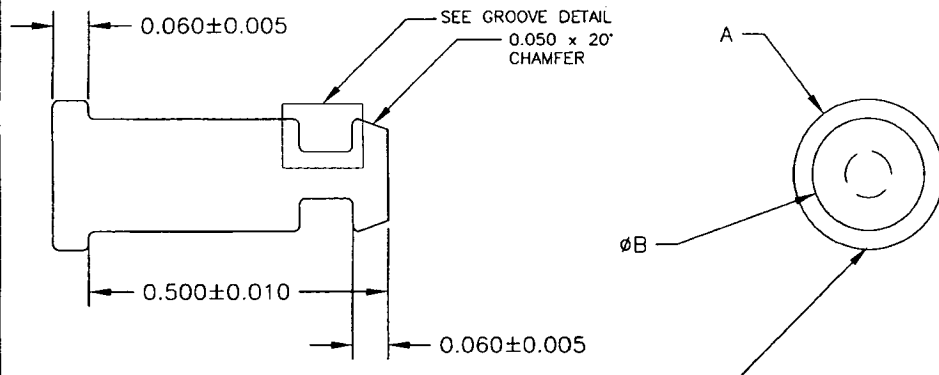
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

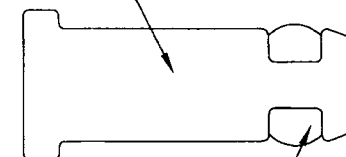
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3492-1/-3/-5/-7 PLUGS IN ACCORDANCE WITH TABLE 1

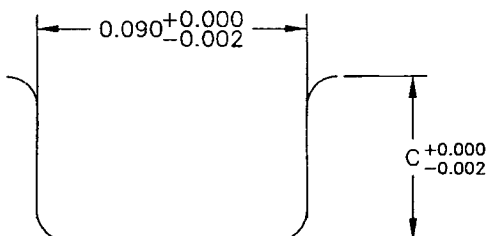
D3492-1/-3/-5/-7 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-005/-007/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

**D3492-041/-043/-045 PLUG ASSEMBLY**

**RELEASED**  
06.05.11  
P/N: EUN #861



GROOVE DETAIL

**TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS**

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500

B

**D3492-1/-3/-5/-7 PLUG NOTES**

- MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- BREAK ALL SHARP CORNERS 0.010 MAX

NO  
WORK ORDER  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

**D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST**  
(TABLE 2)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D3492-041	PLUG ASSEMBLY
	X			D3492-043	PLUG ASSEMBLY
		X		D3492-045	PLUG ASSEMBLY
			X	D3492-047	PLUG ASSEMBLY
1				D3492-1	PLUG
	1			D3492-3	PLUG
		1		D3492-5	PLUG
			1	D3492-7	PLUG
		1		NAS1611-005	O-RING
			1	NAS1611-007	O-RING
1				NAS1611-010	O-RING
	1			NAS1611-013	O-RING

B

B

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

B	06.05.11	ADD -047; UPDATE DIM A,-045
A	06.01.04	NEW ISSUE
DESIGN	PH	DRAWN BY #4
CHECKED	#4	APPROVED #4
DATE	06.05.11	TITLE PLUG
DART AEROSPACE USA, INC.		PORT HADLOCK, MA
DRAWING NO. D3492		REV. B SHEET 1 OF 1
		SCALE NTS

